

KT-413

Classification

| | |
|-----------------|-------------|
| AWS A 5.1/A5.1M | E6013/E4313 |
| JIS Z3211 | E4313 |
| EN ISO 2560-A | E35 0 R 1 2 |
| GB T5117 | E4313 |

Coating Type: High Titania

Applications and Features

- (1) KT-413 is a high titania type electrode for mild steel.
- (2) Stable arc, shallow penetration, and excellent burn-through resistance on thin sheet metal.
- (3) Easy strike and re-strike, low spatter, easy slag removal, and good bead appearance.
- (4) Ideal for welding automotive, thin sheet metal, and light steel structure.

Welding Position



Welding Instruction

Please see Appendix A

Typical Weld Metal Composition (wt%)

| C | Si | Mn | P | S |
|------|------|------|-------|-------|
| 0.07 | 0.36 | 0.45 | 0.023 | 0.007 |

Typical Weld Metal Mechanical Properties

| Tensile strength | Yield strength | Elongation | Charpy V-Notch | |
|-------------------|-------------------|------------|----------------|----|
| N/mm ² | N/mm ² | % | °C | J |
| 491 | 427 | 25 | 0 | 71 |

Available Sizes and Welding Parameters (AC/DC±)

| Diameter (mm) | | 2.6 | 3.2 | 4.0 | 5.0 | 6.0 |
|---------------|---------|--------|---------|---------|---------|---------|
| Current (A) | F/HF | 70~110 | 110~150 | 130~190 | 170~240 | 230~300 |
| | V-up/OH | 40~70 | 60~120 | 110~160 | - | - |